



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBST4241-15
Job Sheet 199255



Part No: RBST4241-15

Job Qty: 6 pcs

Part Name: Locating Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/15/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST4241 Rev 1 IPP Rev. A 19.08.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-154 - 1	6 pcs	10/7/19	10/7/19	1.00	1.50	SL-154 - 1		MSP 19/09/19
120	QC 2	6 pcs	10/7/19	10/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		MSP 19/09/19
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S214984



Part: RBST4241-15

Job No: 199255

Serial No/Batch: S214984

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 09/18/19

130 QC 8	6 pcs	10/7/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	2019-09-20
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				150 Outsource - 12 - Black Oxide	6 pcs
160 Packaging 2-1 - Receive - B4B	6 pcs	10/7/19	0.00 0.00	Packaging 2 - 1 - B4B	2019-09-27
Packaging 2 - 2 - B4B					
Packaging 2 - 3 - B4B					
Packaging 2 - 5 - B4B					
Packaging 2 - 4 - B4B					
Packaging 2 - 6 - B4B					
Packaging 2 - 7 - B4B					
Packaging 2 - 8 - B4B					
Packaging 2 - 9 - B4B					
Packaging 2 - 10 - B4B					
Packaging 2 - 11 - B4B					
Packaging 2 - 12 - B4B					
Packaging 2 - 13 - B4B					
Packaging 2 - 14 - B4B					
Packaging 2 - 15 - B4B					
Packaging 2 - 16 - B4B					
Packaging 2 - 17 - B4B					
Packaging 2 - 18 - B4B					
Packaging 2 - 19 - B4B					
Packaging 2 - 20 - B4B					
Packaging 2 - 21 - B4B					
Packaging 2 - 22 - B4B					
Packaging 2 - 23 - B4B					
Packaging 2 - 24 - B4B					
Packaging 2 - 25 - B4B					
Packaging 2 - 26 - B4B					
Packaging 2 - 27 - B4B					
Packaging 2 - 28 - B4B					
Packaging 2 - 29 - B4B					

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				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	6 pcs	10/7/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	DAS
				QC 6 - 61	61
				QC 6 - 40	9-89
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	6 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	28
				Packaging 3 - 7 - B4B	9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	6 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 110 - MORJ SL-154 LATHE -1-Machine as per FOLIO FC 975 FOLIO REV: AA DWG REV:

Descriptions: 1 2-Debur

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

150 - Issue P/O; 44559 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;

1018 -Certificate of Conformity is required

160 - Receive & Inspect for Damage & Mat'l Certs

170 - QC6- All purchased or subcontracted products

8/15/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

180 - Identify as per dwg & Stock Location:

210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-HRS-P-0.375	Hot Rolled Steel Plate 0.375" (44W)	.4260 sf (.071 ea)	110-SL-154 - 1	5039965 5039965

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-SL-154 - 1	MT-HRS-P-0.375 M1018R0.375	0	32	0

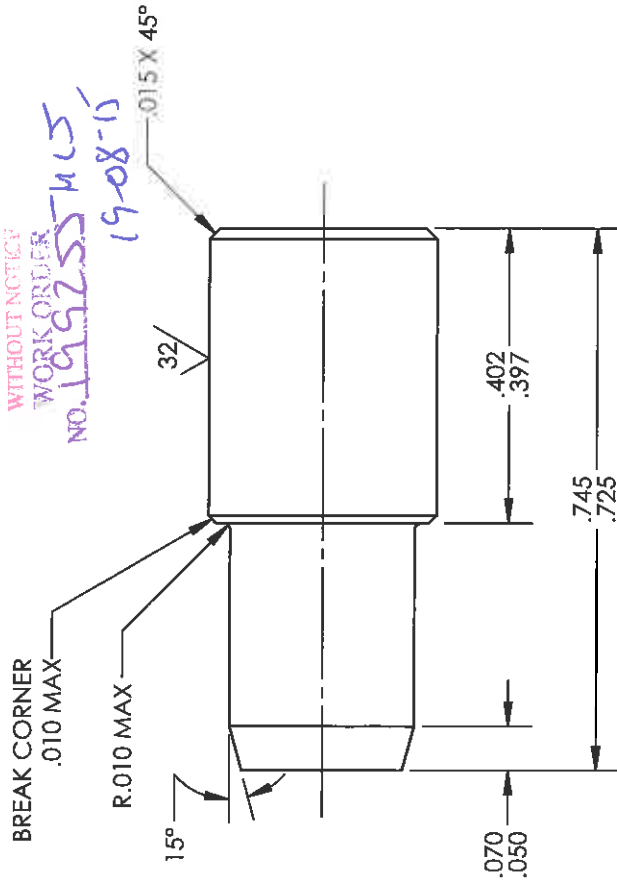
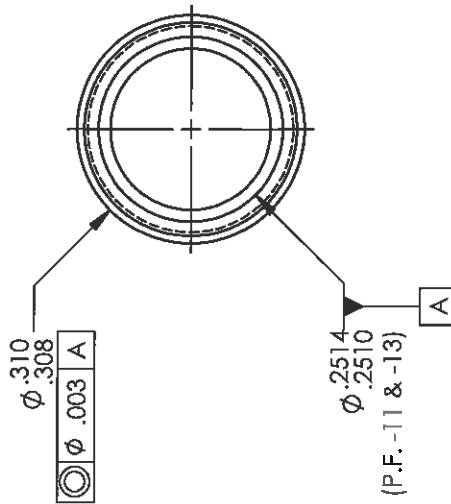
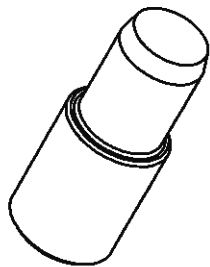
Part Specifications

Specifications could not be found.

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REV		ECR		DESCRIPTION		REVISIONS	
REV	DATE	ECR	DATE	DESCRIPTION	INITIAL	APPROVED	



SHOP COPY
 RETURN TO
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 199255-115
 19-08-15



TITLE DRILL PRESS SWAGING TOOL

DWG NO. RBST4241-15

REV 1

MATERIAL 1018/1020 CR		UNLESS OTHERWISE SPECIFIED	
FINISH BLACK OXIDE		DIMENSIONS ARE IN INCHES	
SPEC QMSI-6.2.2, B.O. REV D		XXX $\pm .005$ FRACTIONS $\pm 1/8$	
DRAWN BY: DD 04/05/2017		XX $\pm .01$ ANGLES $\pm .5^\circ$	
CHECKED: SM 04/05/2017		X $\pm .1$ SURFACES = 125/	
OPPS APPR: AA 04/05/2017		1. BREAK ALL SHARP EDGES	
QA APPR: JL 04/05/2017		2. DIMENSIONAL LIMITS APPLY	
APPROVED: JAG 04/06/2017		3. INTERPRET DIM AND TOL PER	
SCALE 4:1		ASME Y14.5M-2009	
DATE 4/5/2017		USED ON MODEL	
SHEET 9 OF 9			

-15-

LOCATING PIN

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		DEPARTMENT/PROCESS		MRB (QS1042)	
Date : _____		Sequence #: _____		QTY Affected : _____			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
Completed By		Lead hand / Supervisor					
QC / QA Coordinator		Other/Details:					



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Tel (613) 632-5200

PURCHASE ORDER

POHB044559



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044559

PO Date: 9/23/19

Due Date: 10/1/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-09-24

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199047	RBW6510G05731-6F-2	Support -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed		10/1/19	6 pcs	0 pcs	6 pcs	\$6.95/pcs	\$41.70
2	199141	RBW6522A00231-W142AJ-3T-5A	Insert (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed		10/1/19	6 pcs	0 pcs	6 pcs	\$2.69/pcs	\$16.14



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PURCHASE ORDER

POHB044559



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	199037	RBW6510G04631-6F-6	Bracket -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		10/1/19	12 pcs	0 pcs	12 pcs	\$1.85/pcs	\$22.20
				X12							DP
						SEP 26 2019					
4	197520	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -		10/1/19	50 pcs	0 pcs	50 pcs	\$2.50/pcs	\$125.00
				X50							DP
						SEP 26 2019					
5	199255	RBST4241-15	Locating Pin -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed -		10/1/19	12 pcs	0 pcs	12 pcs	\$1.23/pcs	\$14.76
				X12							DP
						SEP 27 2019					
										DAS 61 9-89	
Grand Total:										\$219.80	



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PURCHASE ORDER

POHB044559



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/24/19 12:55 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022664-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupepaltech.com

Bon de Livraison / Packing Slip

022664 - 1

RECEIVED

SEP 26 2019

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
26-Sep-2019		Jigar Patel		POHB044559				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6510G05731-6F-2 Rev.	RBW6510G05731-6F-2 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0
2	RBW6522A00231-W142AJ-3T-5A Rev.	RBW6522A00231-W142AJ-3T-5A OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
3	RBW6510G04631-6F-6 Rev.	RBW6510G04631-6F-6 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0
4	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	50	50	0	0	0
5	RBST4241-15 Rev.	RBST4241-15 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0

DAS
61
9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.